

Work Order ID 147140

June 03, 2016 9:06:12 AM

147140

Rush Shipping
June 17

Page 1

Item ID: D350-591-312

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

20160603

Approvals: Process Plan: SA Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100 Document Control 0.00

100

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

JUN 16 2016

2 Non-enum

MC 1606-16

110 Large Fab 0.00

110

Large Fab Memo 0.07

Large Fab 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M13442/M131562

3-Grind End Plate flush

1 8 BE16-06-13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147140***147140***

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June 03, 2016 9:06:12 AM

Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS
150	QC7-Inspect Chemical Conversion Coat	0.00								18
150										9-89
QC	Memo	0.00				1	0	16-06-14		
Quality Control										

180

0.00

180

Large Fab

Large Fab

Memo

0.07

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod M131562

6-Grind End Plate flush

7-Install last rivet as per Dwg.

16-6-14

14
BE 16-06-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval									

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

147140

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/15/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #	Plan Code
--------	-----------

Accept	Qty
--------	-----

Reject
Qty

Reject Number

**Insp.
Stamp**

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.02

Hand Finishing

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147140

147140

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June 03, 2016 9:06:12 AM

Item ID: D350-591-312 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 6/3/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 134631.</i> Memo START TIME: <i>10:05.</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:35.</i>	0.00 0.04							<i>1 16-06-15. 233</i>
230 *230* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>N11344900</i> Memo	0.04							<i>IRH 16/06/15</i>
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>①</i> <i>DAS 38 9-89</i> JUN 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Misidentified ☐	Past Due ☐	OTHER : ☐							

Work Order ID 147140

June 03, 2016 9:06:12 AM

147140

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250					DAS				
Packaging	Memo	0.00			6				JUN 16 2016
Packaging					9-89				
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.01				DAS			
Quality Control						27			
						9-89			
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312 Location :FG072								

JUN 15 2016

DAS 27 9-89 JUN 15 2016

JUN 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Work Order ID 147140***147140***

Page 7

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.02

Quality Control

JUN 17 2016

MCS JUN 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

June 03, 2016 9:06:18 AM

147140

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

[illegible]

Picklist Print

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Page 2

Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased No

180 Each 1,524.000 16 16

MS20600-AD4W4

Rivets

**

16-6-14 LH

Location

Loc Qty

Loc Code

CCK005

1482

16

M132000

1482

ST308

42

M132640

42

180 Each 7.0000 1 1

**

16-6-14 LH

D3065-041

Manufactured No

D3065-041

Step Leg Assembly

Location

Loc Qty

Loc Code

WA002

7

144118

3

144982

1

145083

3

180 Each 5.0000 1 1

**

16-6-14 LH

D3067-1

Manufactured No

D3067-1

End Plate

Location

Loc Qty

Loc Code

WA003

5

142780

5

250 Each 117.0000 2 2

**

DAS 6 28 9-89 JUN 10 2016

AN3-35A

Purchased No

AN3-35A

Bolt

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

107

m134167

50

m134497

57

DAS 27 9-89

2

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3235-1

Manufactured No

250 Each

70.0000

2 2

D3235-1

Mounting Lug

68-6
9
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST521

20

143809

20

ST546A

50

142565

50

D3278-041

Manufactured No

250 Each

23.0000

1 1

D3278-041

Support Assembly

68-6
9
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST522

23

145580

23

NAS1149D0463J

Purchased No

250 Each

2,993.000

16 16

NAS1149D0463.J

WASHER

68-6
9
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

146

M132035

21

M134508

125

ST260a

1000

M134852

1000

ST263

1847

M134754

1847

JUN 16 2016

Picklist Print

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Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

250

Each

963.0000

4

4

NAS1149D0563.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

237

m125807

2

m133769

235

ST263

627

m134497

627

ST269

99

m128257

99

DAS
6
9-89

DAS
28
9-89

AN5-36A

Purchased

No

250

Each

167.0000

2

2

AN5-36A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

over004

120

M134861

120

ST336

47

M130466

15

M134676

32

DAS
6
9-89

DAS
28
9-89

D2618

Manufactured

No

250

Each

39.0000

2

2

D2618

Bushing

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008A

39

144670

39

DAS
6
9-89

DAS
28
9-89

JUN 16 2016

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Shop Packet Print

Page 4

Picklist Print

Page 5

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Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2230-3
D2230-3
Mounting Lug

Manufactured No 250 Each 185.0000 4 4

DAS
28
6
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	8	
109344	4	
89045	4	
ST521	77	
142522	1	
143805	76	
ST525A	100	
144487	60	
145363	40	

4

D2856-400
***D2856-400*720**
Abrasion Strip 4" Wide (Per Foot)

Manufactured No 250 f 329.4632 1.2 1.2

146220

DAS
28
6
9-89

Location	Loc Qty	Loc Code
ST418	329.46316	
141123	113.46316	
146265	216	

cut (2) D2856-400-720 as per dwg

DAS
27
9-89

DS 9410-011

147831

DAS
28
9-89

DAS
28
9-89

JUN 16 2016

DAS
27
9-89

JUN 16 2016

Picklist Print

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Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

250

Each

1,305.000

2

2

DAS

6

DAS

9-89

28

9-89

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

68

m133790

68

GA

293

m133790

3

m134360

290

ST303

944

m134039

12

m134634

332

m134754

600

DAS
27
9-89

2

DAS

6

9-89

DAS

28

9-89

AN4-13A

Purchased

No

250

Each

653.0000

8

8

DAS

6

9-89

DAS

28

9-89

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

over003

400

m134852

400

ST344

173

m134634

3

m134754

170

DAS
27
9-89

8

JUN 16 2016

June 03, 2016 9:06:18 AM

Shop Packet Print

Page 6

Picklist Print

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Page 7

Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

250

Each

449.0000

2 2

MS21042L5

Nut

**

DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

101

m127813

101

OVER007

100

m134509

100

ST303

248

m134055

6

m134676

42

m134762

200

2

MS21042L4

Purchased

No

250

Each

2,037.000

8 8

MS21042L4

Locknut

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

GA

187

m133769

187

OVER007

1000

m134861

1000

ST303

753

m134676

2

m134762

751

ST305

97

m130922

97

8

DAS
27
9-89

JUN 16 2016

Picklist Print

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Page 8

Work Order ID: 147140

147140

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/3/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

250

Each

1,635.000

4

4

NAS1149D0363.J

Washer

DAS
28
9-89

DAS
6
9-89

JUN 16 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	465	
m134055	465	
ST260a	1000	
m134676	1000	
ST263	170	
m134606	170	

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

20160603

SA

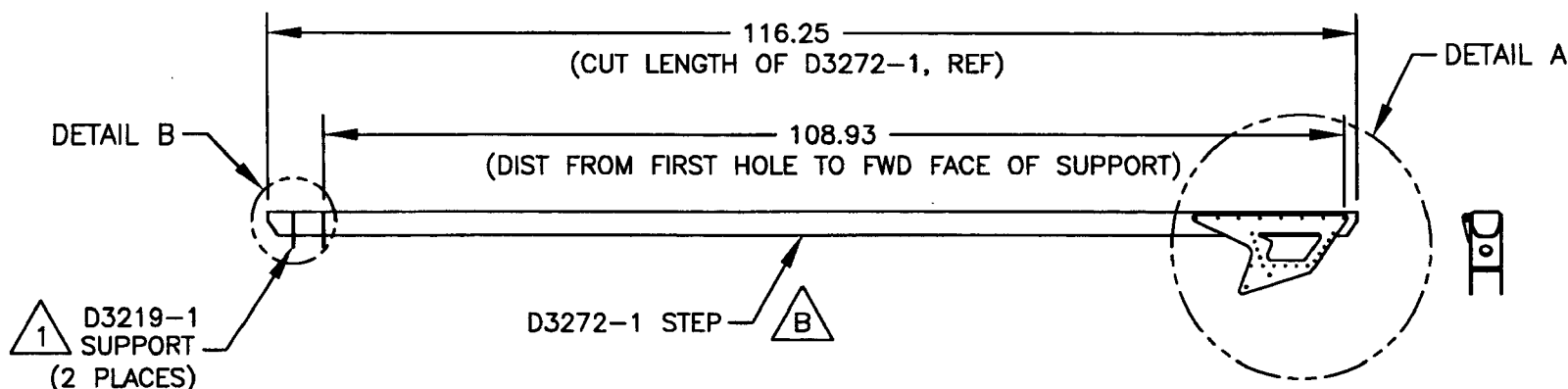
147140

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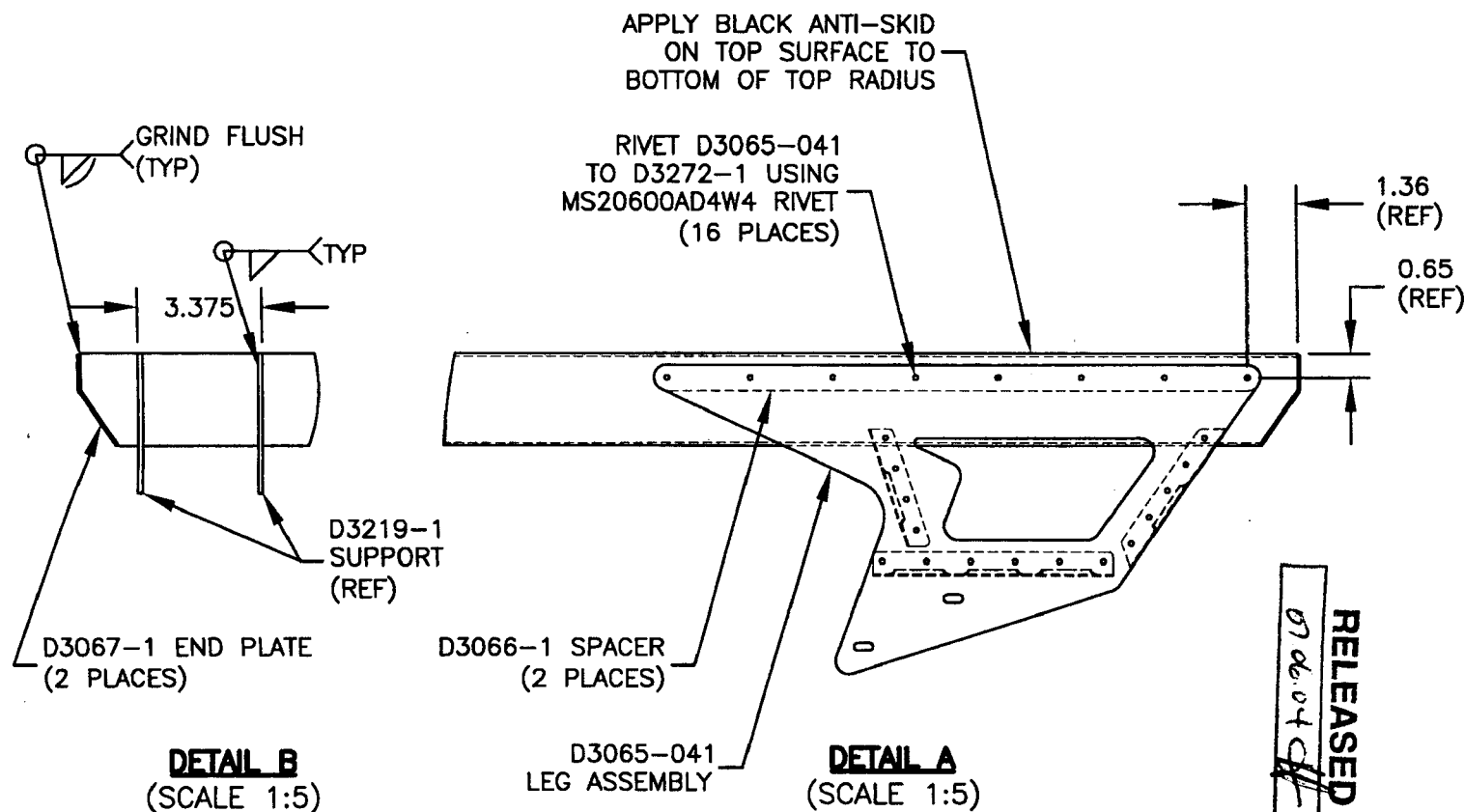
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DART

DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	APPROVED	JE	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

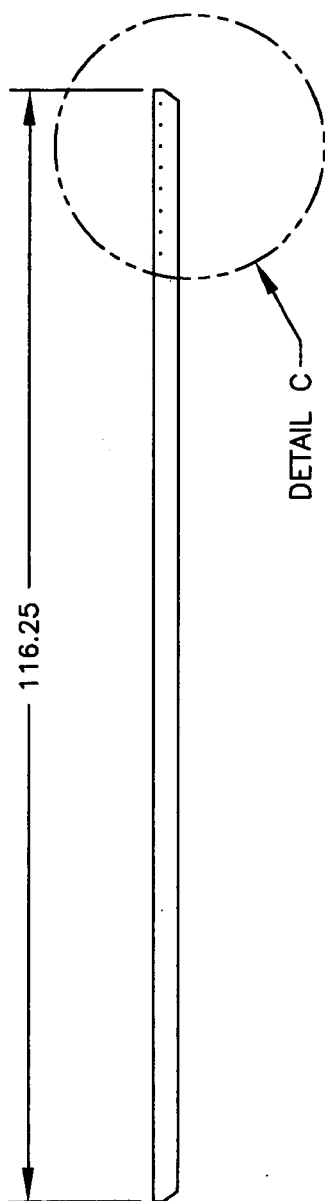




DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

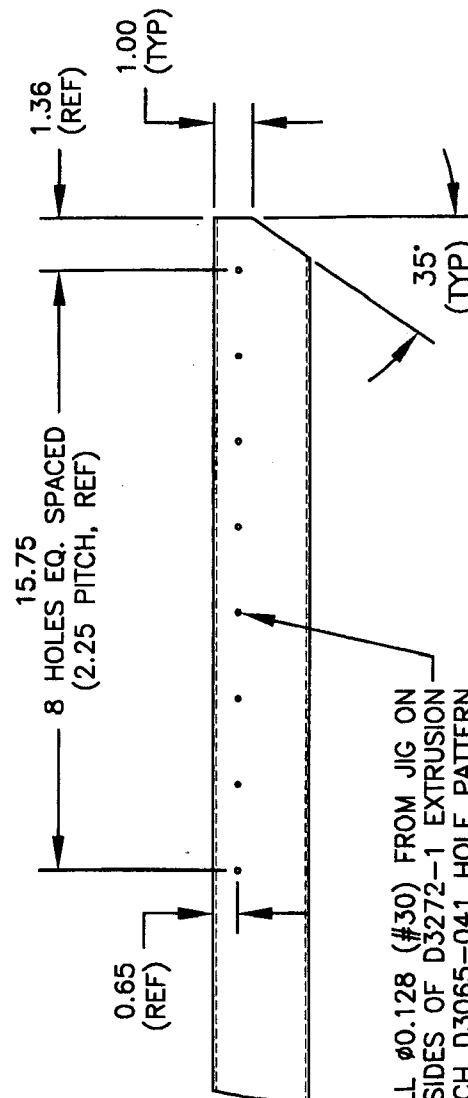
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	CUSHION
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.